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RB KIT 407M-09
Job Sheet 200977


Part No: RB KIT 407M-09 **Job Qty:** 10 pcs
Part Name: Gauge Pin .0800" dia.

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 9/20/19 **Job Tracking No:**
Due Date: 10/14/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	10/14/19		0.00	1.25	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6	GP 19-10-01	
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	10 pcs	10/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61	OCT 02 2019	
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

OCT 08 2019

Part Op 100 - 1-Cut pin in half. 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.
Descriptions: 4-Package as per note 10.
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
21135A54	Plug Gauge 22	5 Ea (.5 ea)	100-Small Fab - 1	5126916

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	21135A54	5	71	0

Part Specifications				
Specifications could not be found.				

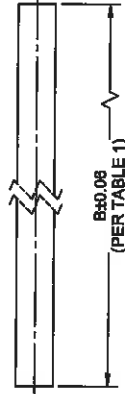
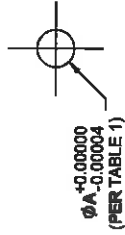


TABLE 1
GAUGE PIN DIMENSIONS

PART NUMBER	ØA	B	PURCHASE PART NUMBER (McMASTER CARR)
RB KIT 407M-01	Ø.02400	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	Ø.04000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	Ø.05400	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	Ø.06000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	Ø.08000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	Ø.09600	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	Ø.10800	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	Ø.12000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	Ø.14400	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	Ø.14400	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	Ø.16000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	Ø.16000	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	Ø.17280	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	Ø.17280	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	Ø.18000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	Ø.19200	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 Ø.XXXX, CLASS X PLUG NO-GO GAUGE

- NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
XX = $\pm 0.01"$ / $\pm 0.5"$
XXX = $\pm 0.005"$ / $\pm 0.1"$
XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	DR	RB KIT 407M
APPROVED	VP	TITLE
DATE	1/17/2019	SPLINE MEASURING KIT
		SCALE
		MTS
		REV. D
		SHEET 3 OF 6

NCR No. _____		Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																	
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QS1042)																	
Description Work Order Deviation								Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐								FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐ Other/Details: _____								Completed By							
																Lead hand / Supervisor							
																QC / QA Coordinator							